

Work Order ID 86052

June 20-12 7:59:32 AM

Item ID: D212-664-107TRN

Accept

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 20/06/2012 Start Qty: 1.00 *1*

Required Date: 04/07/2012 Req'd Qty: 1.00 *1*

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D212-664-147 Rev B(DE0)

100

100

Mori Seiki

Mori Seiki CNC Lathe Large

Memo 0.00

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA705

2-Turn first side as per Folio FA113

3-Blend transition lines only, **do not sand whole tube**

FOLIO REV: A

DWG REV: B

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

110

110

QC

Quality Control

QC1- Inspect dimensions to dimension sheet.

Memo 0.00

0.00

21MCL

12/06/21

21MCL

12/06/21

W/O: 86052

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-664-107TRN PAR #: _____ Fault Category: ~~Machining~~ NCR: Yes No DQA: ~~Not R~~ Date: 12/07/24
 Resolution: _____ Disposition: ~~Will not fix~~ QA: N/C Closed: ~~C~~ Date: 12/7/24

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/7/24	100	OVERALL CUT LENGTH TOO SHORT = 126.41 8.1. Reprogrt emr	GP 12.07.24	Acceptable. Cuff is trimmed after bonding so no effect on part	KL 12-7-24	DP 12-7-24	GP 12/7/24	DAS 16 8-89 12/7/24

NOTE: Date & initial all entries

Work Order ID 86052

June-20-12 7:59:32 AM

86052

Page 2

Item ID: D212-664-107TRN

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crosstube Turning Detail

Stop

NS2

Start Date: 20/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center ID
120***120***

Mori Seiki

Mori Seiki CNC Lathe Large

Operation
DescriptionSet Up/
Run Hours
0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

MORI SEIKI CNC LATHE LARGE

Memo

0.00

1-Turn second side as per Folio FA705

2-Blend transition lines only, **do not sand whole tube**:
*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

FOLIO REV: BDWG REV: B

3- Remove plugs and sand

130

QC1- Inspect dimensions to dimension sheet

0.00

130

QC

Quality Control

Memo

0.00

C Dmnl
12/06/21C Dmnl
12/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86052

June-20-12 7:59 AM

Item ID: D212-664-107TRN

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 20/06/2012 Start Qty: 1.00

Accept

86052

Required Date: 04/07/2012 Req'd Qty: 1.00

1

1

N900040100

Setup Start

NS1

Stop *NS2*

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	D	P					12-7-4

145
145
Crosstubes
Crosstubes

Memo
GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

JW 12-7-9

150
150
HandFXtube
Hand Finishing Crosstubes

Memo
1- Rinsing Wash.

JW 12-7-9
Run

1- Rinsing Wash.
2- Acid Etch.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 86052

June-20-12 7:59:32 AM

86052

Page 4

Item ID: D212-664-107TRN

Accept

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 20/06/2012 **Start Qty:** 1.00 ***1***

Required Date: 04/07/2012 **Req'd Qty:** 1.00 ***1***

Reference:

Approvals: **Process Plan:**

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

160

QC - Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

[Signature] /2-7-18

170

170

Packaging

Packaging

0.00

Memo

0.00

Identify and stock in kanban rack

Location: 10

[Signature] /2-7-18

180

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

[Signature] 12/7/2018

[Signature] MCS 12/07/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-20-12 7:59:35 AM

Work Order ID: 86052

Parent Item: D212-664-107TRN

Parent Item Name: Crosstube Turning Detail

86052
D212-664-107TRN

Start Date: 20/06/2012

Start Qty: 1.00

Required Date: 04/07/2012

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-03-06 DD Verified by:ec
 IPP Rev B Removed polish 08.04.02 EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6019-128		Manufactured	No			110	Each	45.0000	1	1			**

D6019-128

Crosstube Material

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	45	
69803	21	
75635	24	

1
 mark L 12/06/02

Page 1

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	E6052
Description: Crosstube Assembly (205/212/412 Low Fwd)	Part Number:	D212-664-147
Inspection Dwg: D212-664-147 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.313	+/-0.010	313	/	vern	cavc-08
	2.360	+0.005/-0.000	2.360	/	/	
	2.360	+0.005/-0.000	2.360	/	/	
	2.366	+0.005/-0.000	2.367	/	/	
	2.473	+0.005/-0.000	2.478	/	/	
	2.573	+0.005/-0.000	2.574	/	/	
	2.673	+0.005/-0.000	2.678	/	/	
	2.750	+0.005/-0.000	2.750	/	/	
	2.750	+0.005/-0.000	2.750	/	/	
SIDE B	0.313	+/-0.010	313	/	vern	cavc-08
	2.360	+0.005/-0.000	2.364	/	/	
	2.360	+0.005/-0.000	2.365	/	/	
	2.366	+0.005/-0.000	2.371	/	/	
	2.473	+0.005/-0.000	2.478	/	/	
	2.573	+0.005/-0.000	2.574	/	/	
	2.673	+0.005/-0.000	2.677	/	/	
	2.750	+0.005/-0.000	2.756	/	/	
	2.750	+0.005/-0.000	2.750	/	/	
	0.126.528	+/-0.020	126.510	/	tape	46-25

2021
12/06/21

Acceptable.
(Luff trimmed,
no effect on part.)

CP 12/6/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD

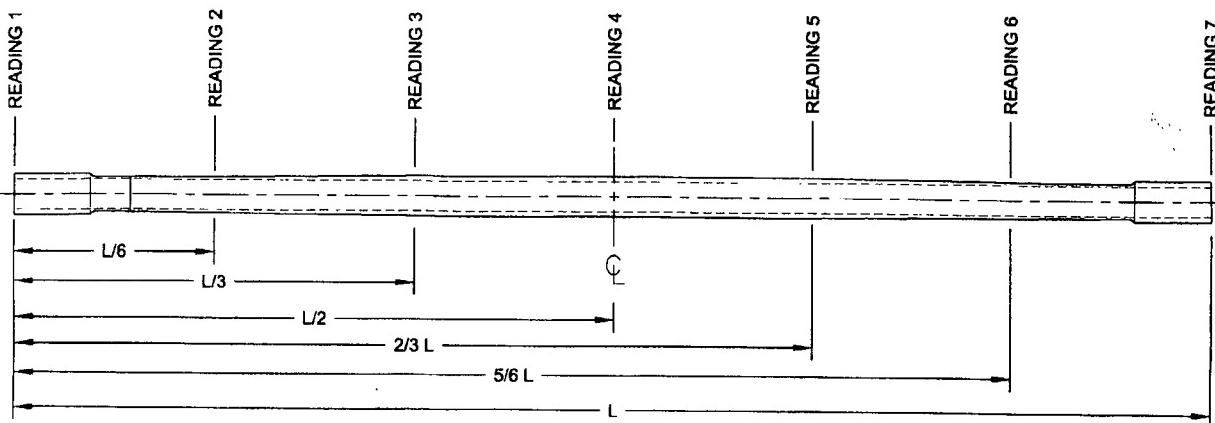
Work Order: 86052

Description: Crosstube Assembly (205/212/412 Low Fwd)

Part Number: D212-664-147

Inspection Dwg: D212-664-147 Rev: B

Page 2 of 2

WALL THICKNESS MEASUREMENT

Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.116	.145	.145	.100	.045	
READING 2 L= 14"	.127	.148	.134	.165	.043	
READING 3 L= 30"	.229	.246	.224	.192	.054	Acceptable
READING 4 L= 63"	.315	.326	.329	.312	.017	0.048"
READING 5 L= 30"	.216	.223	.225	.215	.010	
READING 6 L= 14"	.127	.134	.128	.115	.019	
READING 7 L= 0"	.119	.136	.122	.110	.026	

Calibration Result

Actual Block Thickness: _____

Sitescan 250 Measured Thickness: _____

Measured by:	mml
Date:	12/06/22

Audited by:	D
Date:	12-06-22

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.07	New Issue (P/O D212-664-107)	KJ/EC	
B	10.02.02	Dimension 126.528 was 126.53	KJ	
C	12.06.04	Wall thickness form added	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -147	Qty -147B	Part Number	Description
1	X		D212-664-147	CROSSTUBE ASSEMBLY (205/212/412 LOW FWD)
2		X	D212-664-147B	CROSSTUBE ASSEMBLY (214 LOW FWD)
3	1	1	D6019-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	2	2	D3659-1	CUFF
7	4	4	MS21920-25	CLAMP (OR MS21920-26)
8	44	44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- 1) MATERIAL MANUFACTURED FROM D6019-128
FINISHED LENGTH = 126.528±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4 1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4 2
PAINT OUTSIDE PER DART QSI 005 4 2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES, 0.005 TO 0.010 MAX
- 6) IDENTIFICATION SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUDDY USING VIBRATING STYLUS
- 7) WEIGHT, D212-664-147 = 24.2 lbs (PER IIN-D212-664)
D212-664-147B = 24.2 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) WHEN MACHINING TAPER, RUN CUTTER OFF PART BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 15 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING
- 16) INSTALL D3659-1 CUDDY AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUDDY AND CROSSTUBE SEAL EDGE OF CUDDY TO ENSURE NO GAPS.
- 17) TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. B6052 MJ
12/06/20

DEO ATTACHED

1 per ECN #11-614
11/07/26
UNDER REVIEW
Q1108.3

RELEASED
2009-10-29

B	REVISE GENERAL NOTES/PART LIST; UPDATE TO CURRENT STANDARDS: ADD -147B (ZN C4-2, D4-2)		RF	09.09.30
A	NEW ISSUE		CP	07.07.07
REV.	DESCRIPTION	BY	DATE	
DESIGN	<u>97</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	<u>97</u>	DRAWING NO.	REV. B	
MFG. APPR.	<u>DA</u>	D212-664-147	SHEET 1 OF 4	
APPROVED	<u>DA</u>	TITLE	SCALE	
DE APPR	<u>DA</u>	CROSSTUBE (205/212/412 LOW FWD)	NTS	
DATE	09.09.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS TRADE SECRETS AND PROPRIETARY INFORMATION WHICH IS NOT TO BE USED OR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

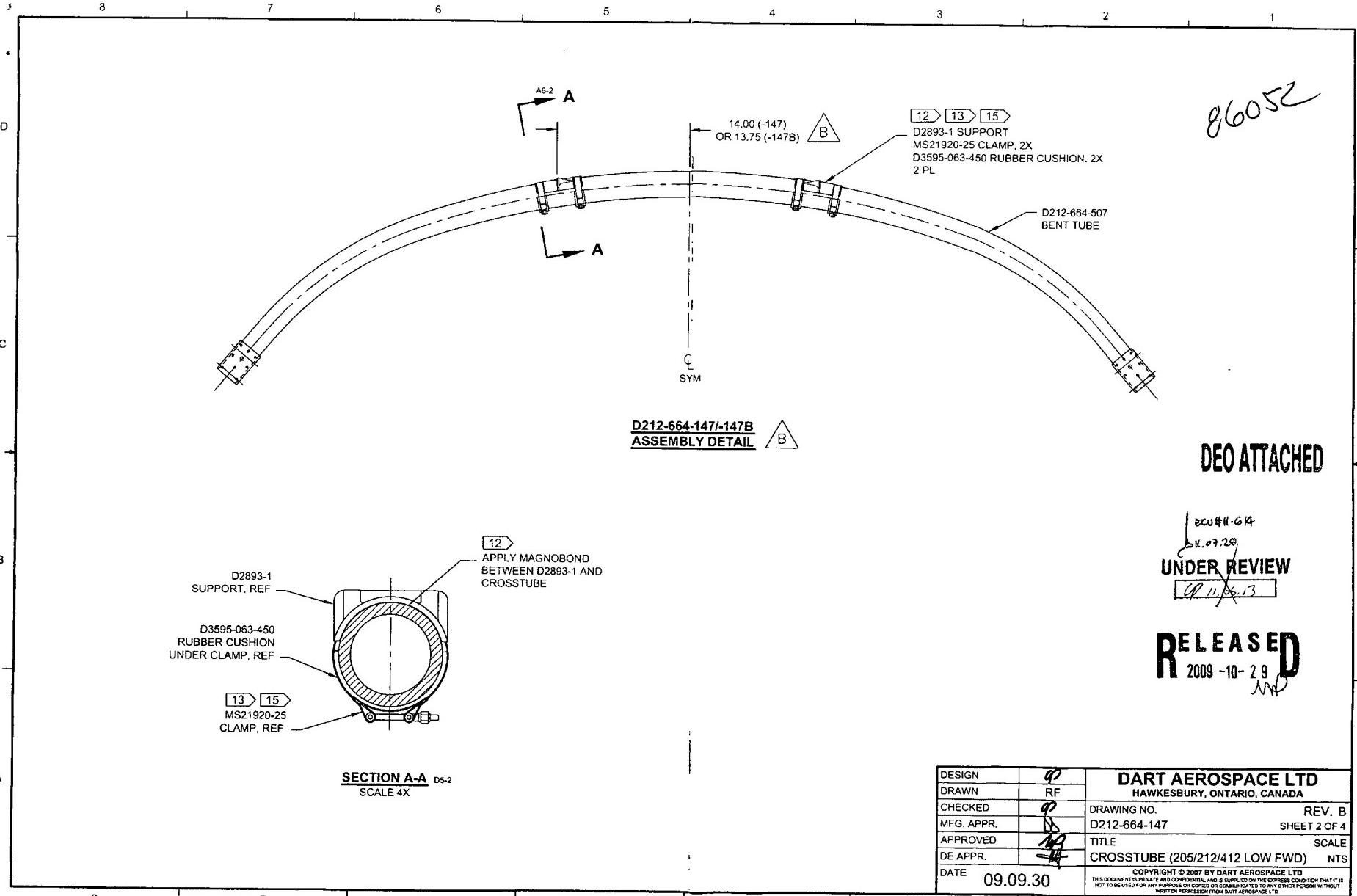
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

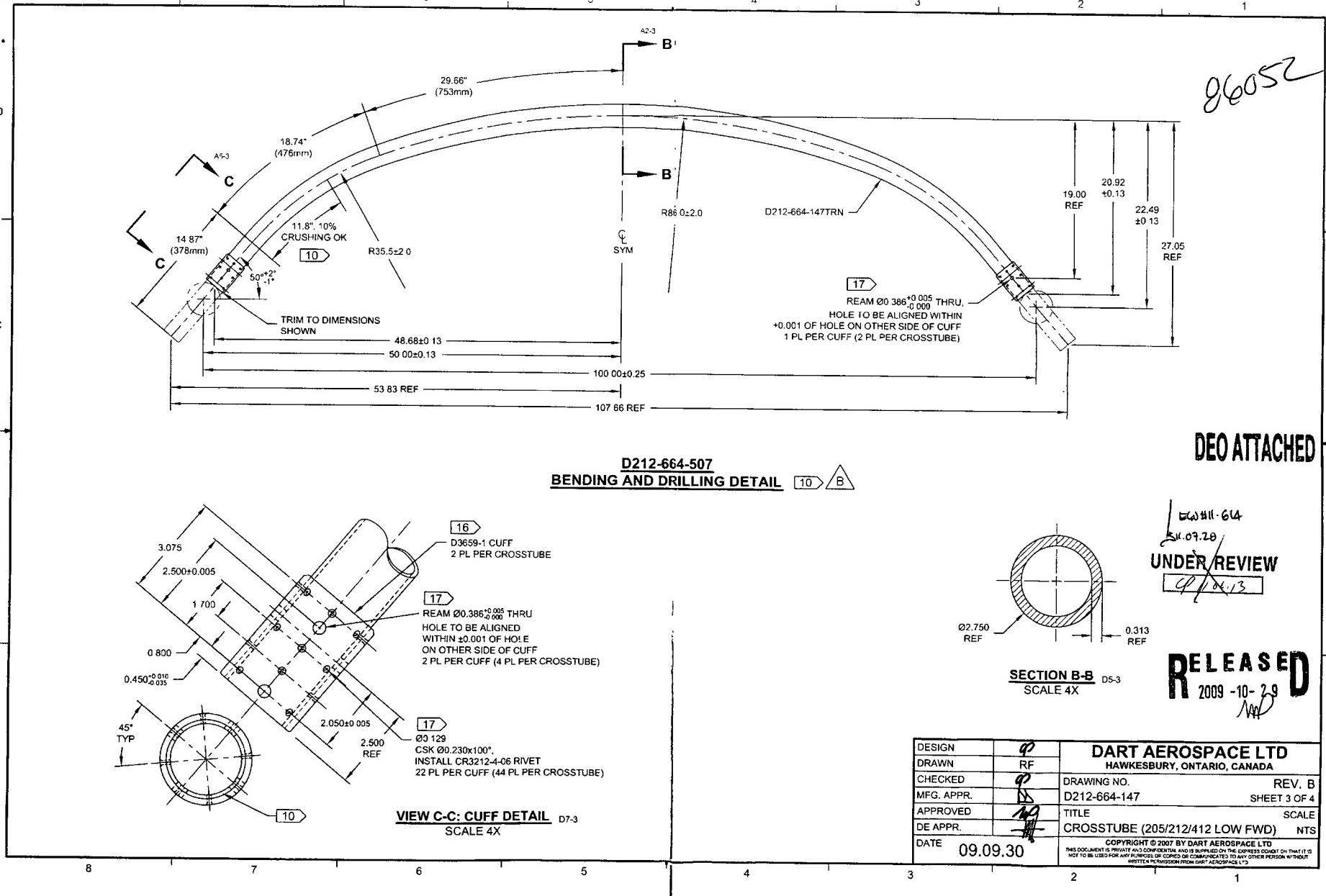


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

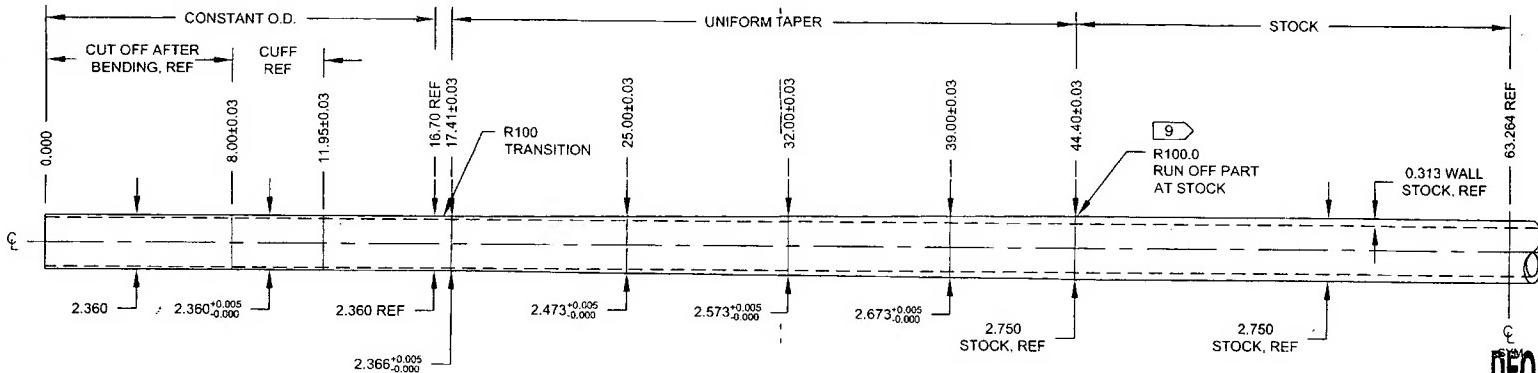
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D212-664-147TRN
TURNING DETAIL

ECO #A-614
11.07.26

~~UNDER REVIEW~~
04/06/13

~~RELEASED~~
2009-10-29
M

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO.
MFG. APPR.	RF	D212-664-147
APPROVED	RF	REV. B
DE APPR.	RF	SHEET 4 OF 4
DATE	09.09.30	SCALE
CROSSTUBE (205/212/412 LOW FWD) NTS		
COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR IN ANY WAY OTHER THAN THAT FOR WHICH IT WAS PROVIDED. WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Appro QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D212-664-147	TITLE CROSSTUBE ASS'Y (205 LOW FWD)	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-147-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>gp</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>AB</i>	APPROVED <i>WJ</i>	DE APPR. <i>WT</i>		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11.07.21	DATE 11.07.21	DATE 11.07.21	

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

g6052

CHANGE:

IS:

Item	Qty -147	Qty -147B	Part Number	Description
9	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2893-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

*RELEASED
2011-07-28
WJ*

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty.	Approval Chief Eng / Prod.Mgr	Appro QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries